

Work Order ID 160077

Thursday, April 20, 2017 2:04:10 PM

160077

Page 1

Item ID: D4775-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Strut Assembly
Start Date: 4/20/2017 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 4/25/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference: (P.A.)SCHEDULED/S
APR 20 2017

Approvals: Process Plan: DAS 21 9-89 Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4775	C ✓

110 Pick Kit 0.00
110 Large Fab
Packaging Memo 0.00
Packaging

20 APR 21 2017 DAS 19 9-89

120 0.00
120
Small Fab Memo 1.79
Small Fab

20 0 17-4-24 DAS 19 9-89

1- APPLY PROSEAL ON D4776-1 STRUT AND ASSEMBLE AS PER DWG
A/R PROSEAL BATCH: 136953
2- ENSURE HELICOIL DOES NOT BLOCK HOLE (SEE NOTE 9)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.20				<u>20</u>			DAS 38 9-89 APR 24 2017
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>5-35</u> Memo	0.00 0.10				<u>20</u>		APR 26 2017	DAS 6 9-89
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 1.00						<u>17/4/2017</u>	

DAS
21
9-89

APR 27 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Picklist Print

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Work Order ID: 160077

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Parent Item: D4775-041

D4775-041

Parent Item Name: Strut Assembly

Start Date: 4/20/2017

Required Date: 4/25/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS
REV:B 13.08.26 PB1 DD VERF:JLM
13.09.26 AS PER REV.B DD VERF:JLM
AS PER REV.C DD VERF:JLM
IPP
IPP REV:C
IPP REV:D 14.01.10

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4775-1 *D4775-1* Strut Tube		Manufactured	No			110	Each	20.0000	1	10.20			DAS 6 9-00
**													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST357			20				APR 21 2017		
				157011			10						
				158670			10						
D4777-1 *D4777-1* Rod End Bearing		Manufactured	No			110	Each	25.0000	1	10.20			DAS 6 9-00
**													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST125			25						
				156722			5						
				158410			10				10		
				159131			10				10		
D4776-1 *D4776-1* Basket Strut Clevis		Manufactured	No			110	Each	14.0000	1	10.20			DAS 6 9-00
**													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST124			14				158666xb		
				156923			4				70		
				157220			10						

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Work Order ID: 160077

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Parent Item: D4775-041

D4775-041

Parent Item Name: Strut Assembly

Start Date: 4/20/2017

Required Date: 4/25/2017

Start Qty: 10.00

Required Qty: 10.00

D4776-5

Manufactured No

110

Each

133.0000

4

40.80

D4776-5

Spacer

**

APR 21 2017

DAS 6 8-03

Location

Loc Qty

Loc Code

ST125

133

157023

12

157324

61

158671

60

12

8

60

AN3-10A

Purchased

No

110

Each

276.0000

2

20.40

AN3-10A

Bolt

**

APR 21 2017

DAS 6 8-03

Location

Loc Qty

Loc Code

GA

60

m136787

60

over003

200

m137321

200

ST349

16

m136665

16

24

10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
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Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
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Picklist Print

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Work Order ID: 160077

160077

Parent Item: D4775-041

D4775-041

Parent Item Name: Strut Assembly

Start Date: 4/20/2017

Required Date: 4/25/2017

Start Qty: 10.00

Required Qty: 10.00

MS21042L3

Purchased

No

110

Each

2,166.000

2

20 40

**

DAS
6
3-89

MS21042L3

Nut

Location

Loc Qty

Loc Code

APR 21 2017

FP001

100

m135945

100

GA

168

m134360

102

M136665

66

OVER007

1300

m134360

0

M136665

300

m137321

1000

ST303

598

m137073

98

m137166

500

40

MS21209-F615

Purchased

No

110

Each

111.0000

1

10 20

**

DAS
19
2-80

MS21209-F615

Heli-Coil

Location

Loc Qty

Loc Code

GA

111

m135058

18

m136835

93

23

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Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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240 27 10								Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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